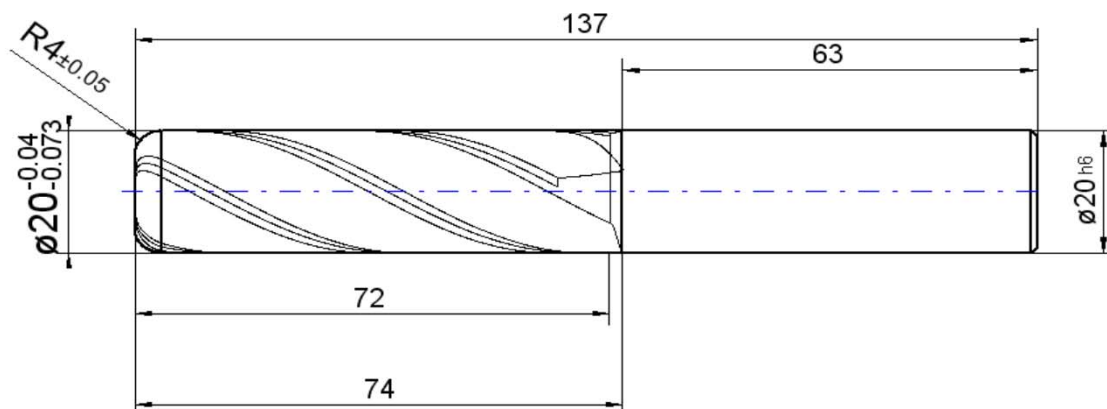


## Multipitch Radius-Endmill Ø20 Z2+2 R4

A01-112



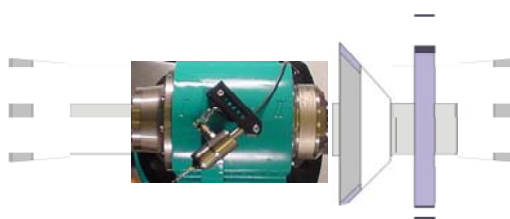
### 1. Cycletime for Production

Workpiece: Ø20 Ltot 137, LC 72 mm Material CARBIDE							
Operations	Probe	Flute 1	Gashing	O.D.2	O.D.1	End 2	End 1
Feed [mm/Min]	2000	40	80	150	300	70	100
Power [kW]		3	2	1	2	1	1
Cutting speed [m/s]		18	20	22	22	22	22
Used wheels		1	2	3	4	1	4
Grinding time [s]	12	583	65	436	231	57	42
Total cycle time	23 Min 45						

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	1A1 Ø125 D64
2	12V9 Ø125 D64
3	11V9 Ø100 D64
4	11V9 Ø100 D64



4

2 1 3

### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG      Coolant: Synthetic Oil, pressure 6 bar  
 Control: Fanuc 310i      Software: Quinto 5  
 Accessories:

Responsible engineer: OP, 27.2.14

[www.schneeberger.ch](http://www.schneeberger.ch)

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland  
 Subsidiaries in: France, Deutschland, Italia, United States, China

